

Work Order ID 72347

Friday, July 22, 2011 2:46:52 PM



Page 1

Item ID: D139-799-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Door Hinge

Start Date: 7/22/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

7-22-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D139-799	<i>E</i>

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D139-799-013
CHG002

003 ECU 11-657

Sulu

for MLS 11-11-2 (6)

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/10/11 (6)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

Sulu

(6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00				11/11/72			
	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per PPP D139-799-013								
	Location: 3A								
	PPP rev: A								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

: CME
11-17-09

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Picklist Print

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Work Order ID: 72347

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge



Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

S46
D2585
Mounting Channel

Manufactured No

110

Each

61.0000

1 6
B732975

Location

Loc Qty

Loc Code

ST017

61

69536

5

70814

56

S46
D2586
Door Latch

Manufactured No

110

Each

84.0000

1 6
B73296

Location

Loc Qty

Loc Code

ST204

84

64774

34

70557

50

S46
D2621
Latch Plate, 350 Spacepod

Manufactured No

110

Each

28.0000

1 6
B73304

Location

Loc Qty

Loc Code

ST019

28

56526

28

S46
D3552-18 23 SEN 11-652
Door Prop

Manufactured No

110

Each

7.0000

1 6
B70101 B73497 11/10/11 6
B74847 11/11/12 B74847 11/11/12

Location

Loc Qty

Loc Code

ST272A

7

69668

7

Dart Aerospace Ltd

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Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

D3622-1



Ball Stud

Manufactured No

110 Each

24.0000

Location

Loc Qty

Loc Code

ST070

24

67284

3

71540

21

Manufactured No

110 Each

38.0000

Location

Loc Qty

Loc Code

ST070

38

53951

38

Manufactured No

110 Each

20.0000

Location

Loc Qty

Loc Code

ST121

20

71535

20

Manufactured No

110 Each

16.0000

Location

Loc Qty

Loc Code

ST119

16

71536

16

Manufactured No

110 Each

11.0000

Location

Loc Qty

Loc Code

ST119

11

71537

11

D4072-3



Airframe Hinge Backing Plate

Manufactured No

110 Each

16.0000

D4072-5



Bushing

Manufactured No

110 Each

11.0000

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Shop Packet Print

Page 2

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Cargo Door Hinge

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

S D4073-1

Manufactured No

110 Each

20.0000

2 112



Door Hinge

Location

Loc Qty

Loc Code

ST120

20

71539

20

Manufactured No

110 Each

14.0000

2 12



Door Hinge Backing Plate

Location

Loc Qty

Loc Code

ST120

14

71541

14

Manufactured No

110 Each

12.0000

1 6



Bracket

Location

Loc Qty

Loc Code

ST122

12

71542

12

Manufactured No

110 Each

15.0000

1 6



Channel

Location

Loc Qty

Loc Code

ST120

15

71543

15

Manufactured No

110 Each

15.0000

6



Backing Plate

Location

Loc Qty

Loc Code

ST122

15

71544

15

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 72347

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

D4074-7

Striker Plate

Manufactured No

110 Each

17.0000

Location

Loc Qty

Loc Code

ST120

17

71546

17

Purchased No

110 Each

1,430.000

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

1430

117441

670

117601

400

117885

360

Purchased No

110 Each

1,320.000

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

1320

116105

5

116548

131

117441

498

117591

100

117611

90

118179

496

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

MS27039-1-10 Purchased No

Screw

110 Each 155.0000

8 48 334
M118612

Location	Loc Qty	Loc Code
ST290	150	
117441	150	
ST291	5	
115935	5	

15x

MS27039-1-14 Purchased No

Screw

110 Each 132.0000

2 10
S

Location	Loc Qty	Loc Code
MEZZ	132	
112312	100	
15924	32	

12

MS27039-1-16 Purchased No

Screw

Each 168.0000

48 162
M118612

Location	Loc Qty	Loc Code
ST292	168	
118384	168	

32

MS27039-1-17 Purchased No

Screw

110 Each 118.0000

1 6
M118612

Location	Loc Qty	Loc Code
ST292	118	
11540	18	
117591	100	

1
5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72347

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0363J

Purchased

No

110

Each

2,796.000

18

108



Washer

Location

Loc Qty

Loc Code

ST298

2796

117505

426

117601

370

118077

2000

110

Each

991.0000

6

108

NAS1149D0663J

Purchased

No



Washer

Location

Loc Qty

Loc Code

ST298

991

115996

5

117291

86

117977

500

118378

400

110

Each

128.0000

4

24

NAS11515H5L

Purchased

No



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

88

111359

5

118378

83

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-13	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

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Revision: E

Date: 11.08.24

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-799 REV. E AND ICA-D139-799 REV. 4

REF. FAA STC: SR02138SE

REFERENCE ONLY

PURPOSE:

THE PURPOSE OF THE DART SERVICE INSTRUCTION (DSI) IS TO CHANGE THE P/N OF THE DOOR PROP USED IN D139-799-013 CARGO DOOR FWD OPENING HINGE KIT FROM D3552-13 TO D3552-23 TO PREVENT THE MODIFIED DOOR FROM HITTING THE MAINTENANCE STEP IN THE DOWN POSITION

PARTS LIST CHANGE:

FOR D139-799-013 AT CHG 003 AND SUBSEQUENT, THE PARTS LIST SHOULD BE CHANGED AS FOLLOWS:

5.0 D139-799-013 Cargo Door Hinge Kit (IIN-D139-799 Rev. E)

52.4 D139-799-013 Cargo Door Hinge Kit (ICA-D139-799 Rev. 4)

QTY. -013	PART NUMBER	DESCRIPTION
X	D139-799-013	CARGO DOOR HINGE KIT

IS:

1	D3552-23	DOOR PROP
---	----------	-----------

WAS:

1	D3552-13	DOOR PROP
---	----------	-----------

CUSTOMERS WHO HAVE RECEIVED D139-799-013 AT CHG 002 OR EARLIER CAN OBTAIN THE DSI 9567-011 DOOR PROP KIT FROM DART

QTY -011	PART NUMBER	DESCRIPTION
X	DSI9567-011	DOOR PROP KIT
1	D3552-23	DOOR PROP

PROCEDURE:

REMOVE D3552-13 DOOR PROP AND REPLACE WITH D3552-23 DOOR PROP PER CHAPTER 52 OF ICA-D139-799.

WEIGHT AND BALANCE:

NEGLIGIBLE EFFECT ON WEIGHT AND BALANCE ASSOCIATED WITH THIS CHANGE

A	NEW ISSUE	RF	11.09.27
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD KENT, WA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9567	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR PROP CHANGE	NTS
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